

Work Order ID 73796-2

Thursday, September 15, 2011 11:05:19 AM



For Monday Page 1

Item ID: D3183-045

Revision ID:

Item Name: Bearing Assembly

Start Date: 9/15/2011 Start Qty: 60.00

Required Date: 9/19/2011 Req'd Qty: 60.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

MF

Date: 11-09-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

Turn D3183-9 Cap as per Folio FA388 Deburr

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Split

66 80.0

Ad

80

11/9/16

80

11/9/16

80

ork 11/09/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73796

Thursday, September 15, 2011 11:05:19 AM



Page 2

Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 9/15/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

Handwritten: 9/15/09/19 (66)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Handwritten: 8/15/19

Handwritten: counts
x66

150



Packaging

Packaging

Identify as per dwg & Stock Location *234*

0.00

Memo

0.00

Handwritten: 11/9/19 sl (66)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73796

Thursday, September 15, 2011 11:05:19 AM



Page 3

Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 9/15/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11

MF
11-09-11

Picklist Print

Thursday, September 15, 2011 11:05:16 AM

Page 1

Work Order ID: 73796

Parent Item: D3183-045

Parent Item Name: Bearing Assembly



Start Date: 9/15/2011

Required Date: 9/19/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A 04.02.18 New issue KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 Bearing		Manufactured	No			110	Each	66.0000	1	60			

Location	Loc Qty	Loc Code
ST235B	50	
71854	50	
ST236	16	
67529	1	
68933	4	
72295	11	

MDELNR1.000

Purchased

No



Delrin Round Bar 1"

130 f 40.3090 0.0333 2.103158

Location	Loc Qty	Loc Code
MAT055	40.309	
117985	0.407	
118257	23.902	
118392	16	

Handwritten notes:
 EP 11/09/19
 50
 124
 SA 11/9/16
 3.5 AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

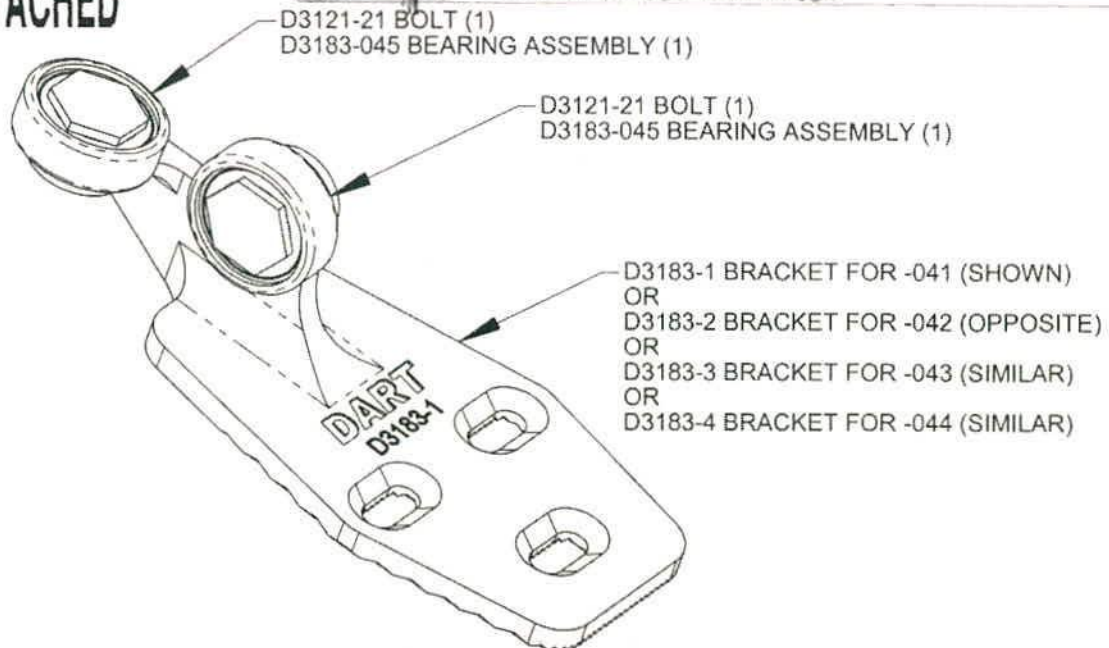
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

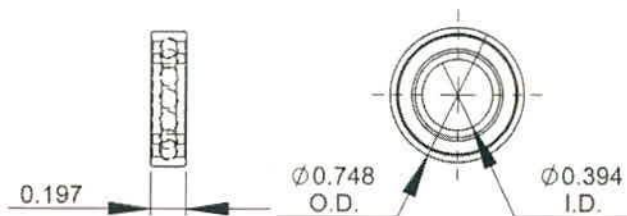
DART

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1	
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04 03 01
DEO ATTACHED

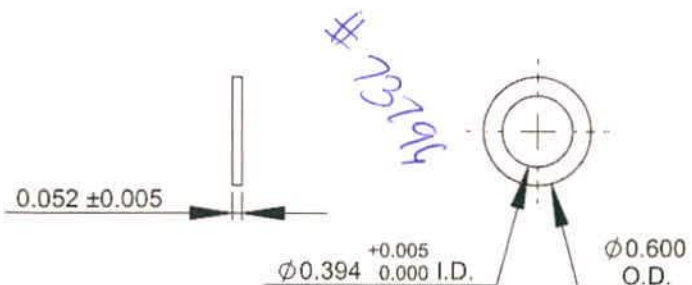


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

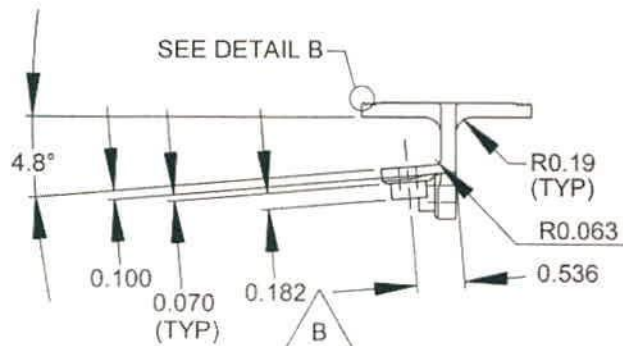
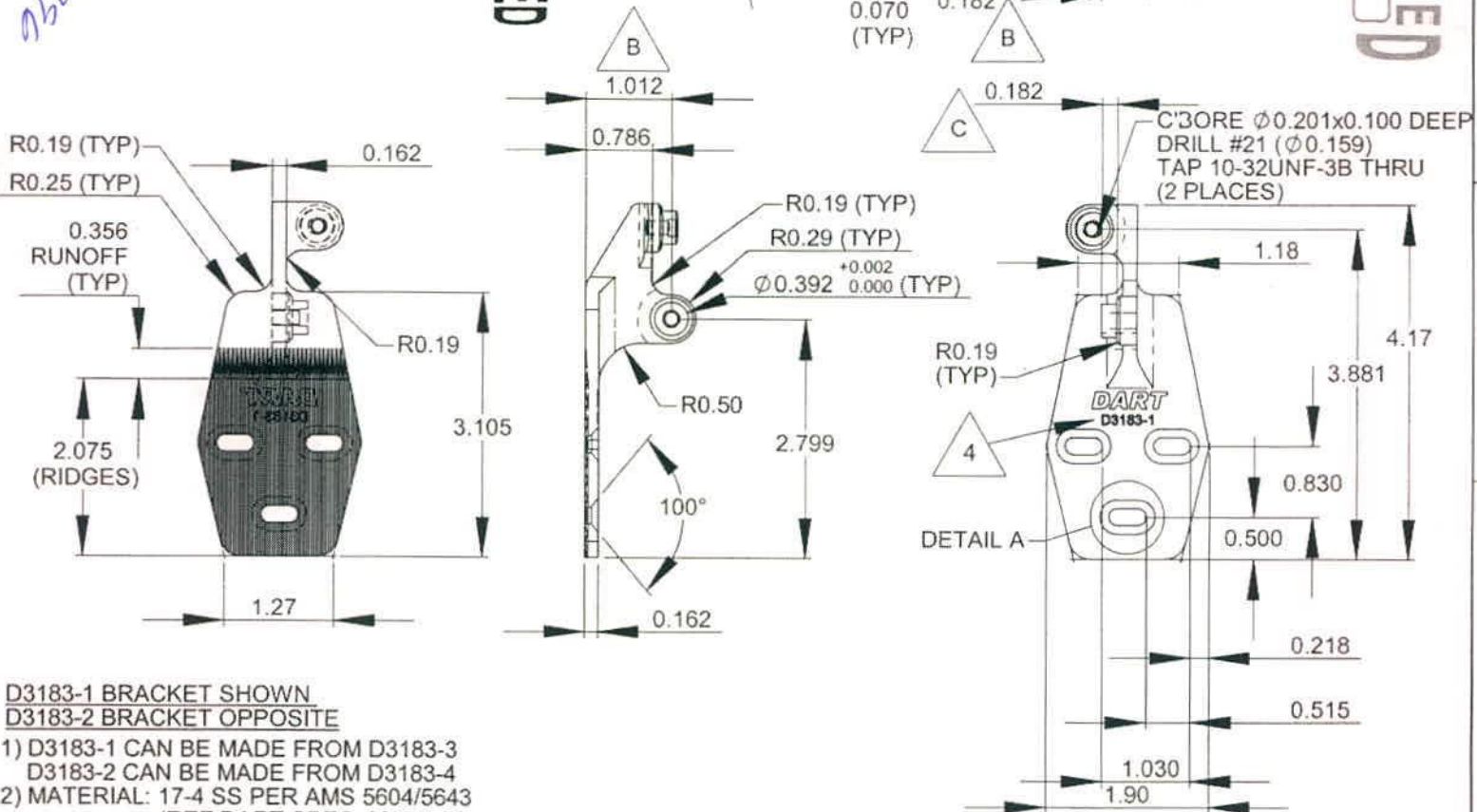
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	TITLE D3183	REV. C
	BRACKET ASSEMBLY	SHEET 2 OF 4
		SCALE 1:2

RELEASED
04.03.01**DEO ATTACHED**

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

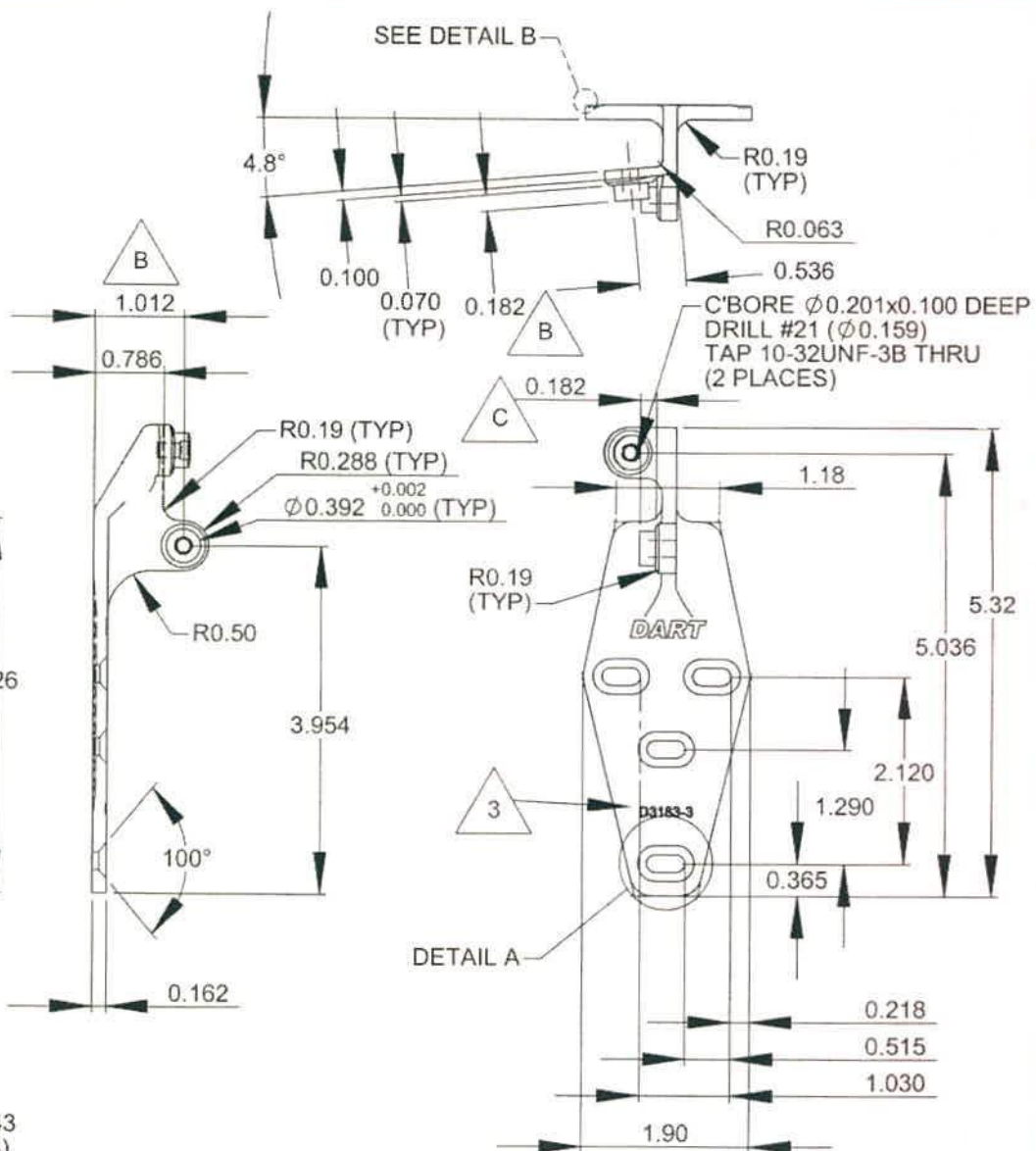
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	TITLE D3183	REV. C
	BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

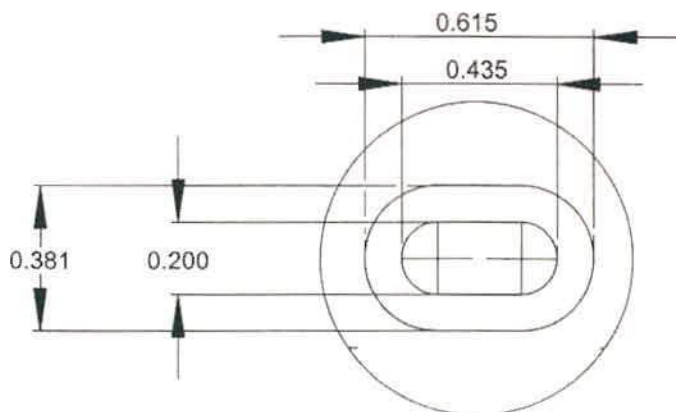
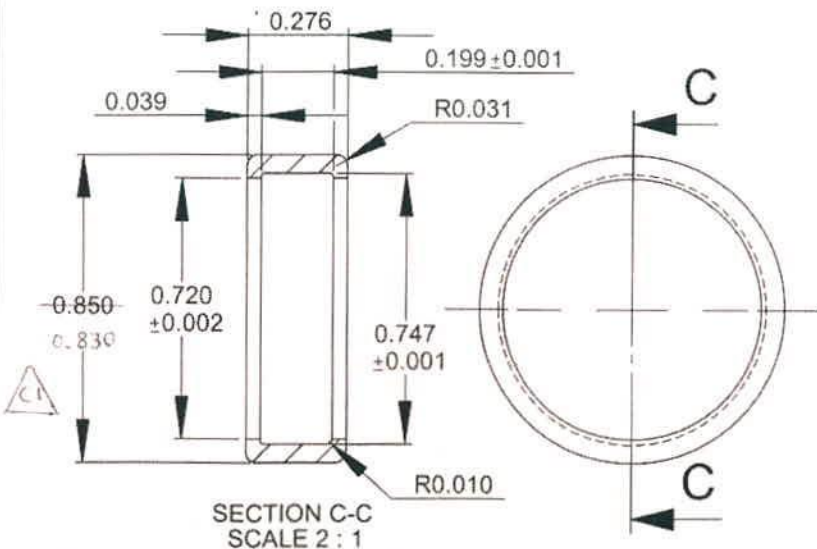
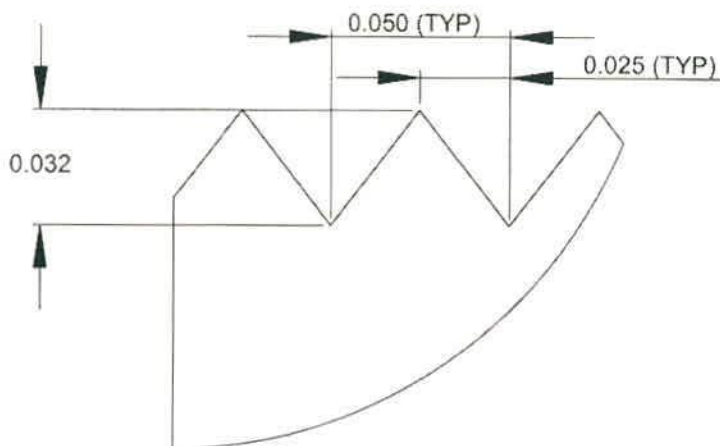
DEO ATTACHED
RELEASED
04-03-01

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

**DETAIL A (2 : 1)****RELEASED**
04.03.01**DEO ATTACHED****DETAIL B (20 : 1)****D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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